

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (canceled).

Claim 2 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~± 16~~, wherein the relief depth ~~(RT)~~ of the relief structures ~~(RS)~~ is less than 1.5 mm, ~~preferably less than 0.8 mm.~~

Claim 3 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~± 15~~, wherein the holding flanks ~~(HF)~~ run in strip shape and at least predominantly horizontally.

Claim 4 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~± 15~~, wherein the holding flanks are disposed several times in the a vertical direction, following one another.

Claim 5 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~± 15~~, wherein the cumulative length of the holding flanks is greater than the circumference of the molded body, ~~preferably greater~~

~~than twice the circumference of the molded body.~~

Claim 6 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~4~~ 15, wherein holding flanks are formed on at least two wall surfaces of the mold cavity that lie opposite one another, with reference to the center of gravity of the molded body.

Claim 7 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~4~~ 17, wherein the relief structure contains grooves ~~(RG, NG)~~ having a concave ~~and/or~~ or convex arched cross-section.

Claim 8 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~4~~ 15, wherein the wall of the mold cavity contains a prismatic wall segment having wall surfaces and the relief ~~(RG)~~ is structures are set back relative to the wall surfaces of the prismatic segment.

Claim 9 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~4~~ 15, wherein the ~~relief is~~ relief structures are formed predominantly in the lower half of the vertical expanse of the walls of the mold cavity.

Claim 10 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~1~~ 15, wherein the mold cavity has a clear cross-section ~~of the mold cavity that~~ widens in the downward direction. in ~~the~~ a vertical progression of the relief structure.

Claim 11 (canceled).

Claim 12 (currently amended): ~~Molding~~ The molding insert as recited in claim ~~1~~ 15, wherein the surfaces of the walls ~~(NW1, NW2)~~ of the mold cavities are hardened.

Claim 13 (new): The molding insert as recited in claim 2, wherein the relief depth of the relief structures is less than 0.8 mm.

Claim 14 (new): The molding insert as recited in claim 5, wherein the cumulative length of the holding flanks is greater than twice the circumference of the molded body.

Claim 15 (new): A molding insert for use with a molding machine for production of compacted molded bodies of material and deposit of the compacted molded bodies in a multi-layer arrangement, the compacted molded bodies being pushed via pressure devices out of the molding insert in a downward direction, said molding insert comprising at least one mold

cavity having a mold cavity interior, a mold cavity volume, and a plurality of walls comprising relief structures for forming counterrelief structures on the molded body formed in the mold cavity,

wherein said relief structures comprise depressions for forming projections on lateral surfaces of the molded body formed in the mold cavity, the depressions having holding flanks that are downwardly inclined toward the mold cavity interior at an angle no more than thirty degrees from the walls, the relief structures being coordinated with the mold cavity volume and the material of the molded body so that the molded body remains in the mold cavity until pushed out via a pressure device without shearing off the projections located within the depressions.

Claim 16 (new): A molding insert for use with a molding machine for production of compacted molded bodies of material and deposit of the compacted molded bodies in a multi-layer arrangement, the compacted molded bodies being pushed via pressure devices out of the molding insert in a downward direction, said molding insert comprising at least one mold cavity having a mold cavity interior, a mold cavity volume, and a plurality of walls comprising relief structures for forming counterrelief structures on the molded body formed in the mold cavity,

wherein said relief structures comprise depressions for forming projections on lateral surfaces of the molded body formed in the mold cavity, the depressions having a relief depth, holding flanks that are downwardly inclined toward the mold cavity interior, and concave or

convex regions having a radius of curvature that is at least five times greater than the relief depth, the relief structures being coordinated with the mold cavity volume and the material of the molded body so that the molded body remains in the mold cavity until pushed out via a pressure device without shearing off the projections located within the depressions.

Claim 17 (new): A molding insert for use with a molding machine for production of compacted molded bodies of material and deposit of the compacted molded bodies in a multi-layer arrangement, the compacted molded bodies being pushed via pressure devices out of the molding insert in a downward direction, said molding insert comprising at least one mold cavity having a mold cavity interior, a mold cavity bottom, a mold cavity volume, and a plurality of walls comprising relief structures and spacer-forming depressions for respectively forming counterrelief structures and spacer elements on the molded body formed in the mold cavity,

wherein said relief structures for forming counterrelief structures comprise depressions for forming projections on lateral surfaces of the molded body formed in the mold cavity, the depressions having a relief depth and holding flanks that are downwardly inclined toward the mold cavity interior, the relief structures being coordinated with the mold cavity volume and the material of the molded body so that the molded body remains in the mold cavity until pushed out via a pressure device without shearing off the projections located within the depressions, and

wherein said spacer-forming depressions for forming spacer elements
have a greater depth than the relief depth and are open toward the mold
cavity bottom.